

Work Order ID 55049

January 5, 2010 1:51:15 PM

Page 1

Item ID: D3705-3

Accept



Setup Start



Revision ID:

Item Name: COVER PLATE

Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: 10-1-05

Tooling:

Date:

Res Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3705	Rev C
-------	-------

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

PL 10-1-7

FLOW CNC Waterjet

1-Cut as per Dwg D3705 Dwg Rev: *C* Prog Rev: *C*

grain direction along 26.57** 12- Deburr if necessary

(9)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

PL 10-1-7

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

*→ S10 loc 02**69*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55049

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Page 2

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Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cast Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- COUNTER SINK AS PER DWG 12- BEND AS PER DWG D3705

140



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

=> 10/01/18

0.00

SB - 10/01/18 9

(X) ✓

150



Identify as per dwg & Stock Location: 175

0.00

Packaging

Memo

0.00

10-1-18 (9) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 55049

Page 3

January 5, 2010 1:51:15 PM

Accept



Setup Start



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Revision ID:

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Start Date: 05/01/2010 Start Qty: 6.00



Required Date: 15/01/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/01/10 HJ

Quality Control

MF 10-1-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 1:51:20 PM

Page 1

Work Order ID: 55049



Parent Item: D3705-3



Parent Item Name: COVER PLATE

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	275.3809	4.4400	6.66		HR 10-1-7

6061-T6 .080 Sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT	275.38087	
110630	33.5136	
112141	0.86727	
113438	241	113438

(9)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55044
Description: COVER PLATE	Part Number:	D3705-3
Inspection Dwg: D3705-3 Rev: C		Page 1 of 1

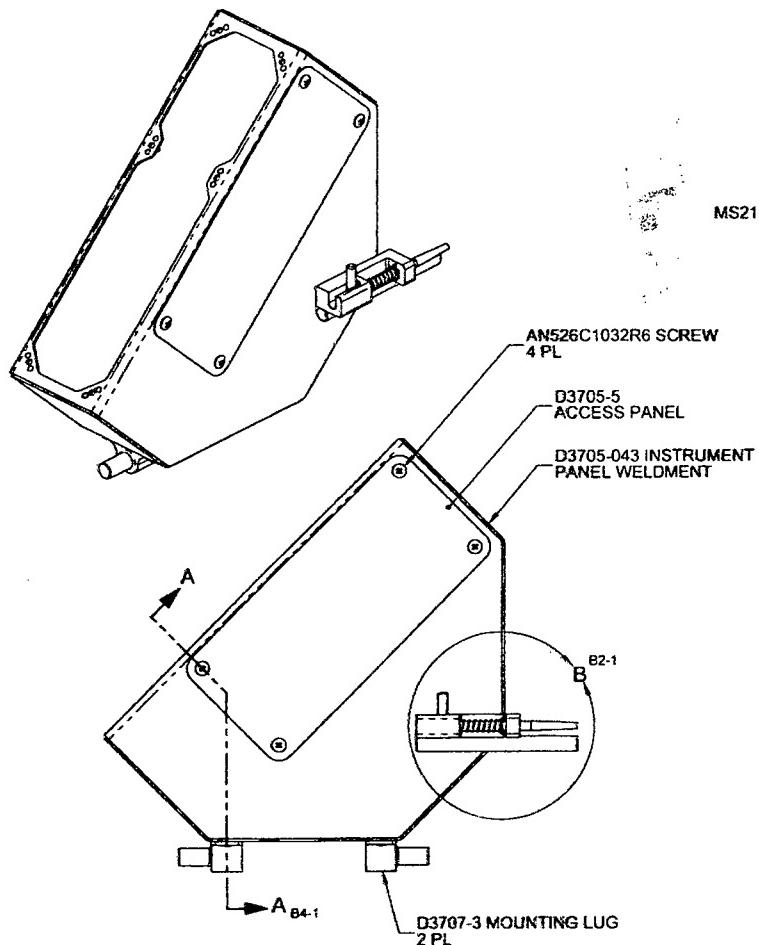
FIRST ARTICLE INSPECTION CHECKLIST

x First Article **■** Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 10-1-7	Date: 10/4/02	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

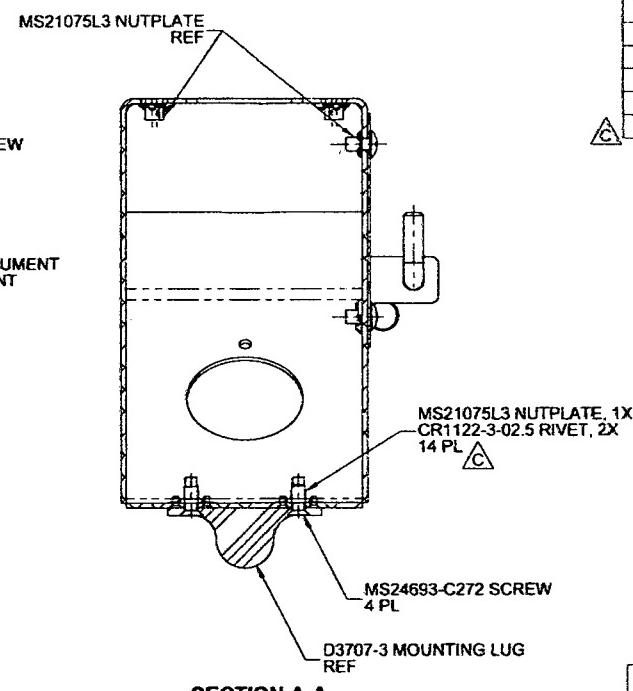
8 7 6 5 4 3 2 1



D3705-041 INSTRUMENT PANEL ASSY'

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.97 lbs

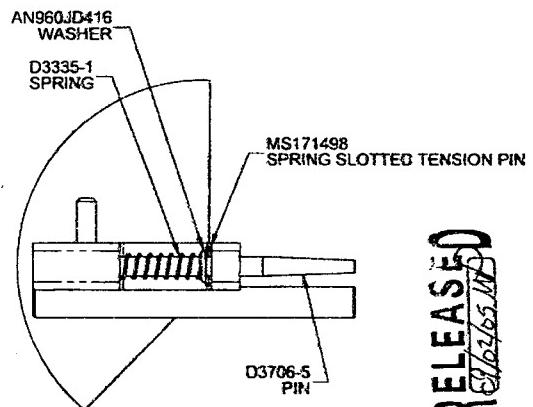


SECTION A-A
SCALE 2X
B7-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55049

B7 10-1-05

ITEM	QTY	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASSY'
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	1	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET



C	ADDED D3705-7/9-11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3). 0.190 WAS 1.50 (ZN D5-4); ADDED Ø.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35489-156; QTY. 14. MS21075L3 WAS QTY. 8; QTY. 28 MS20426AD3-3 WAS QTY. 16. MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD16L (ZN D5-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>16</i>	DART AEROSPACE LTD	
DRAWN	<i>16</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>TS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DS</i>	D3705	SHEET 1 OF 6
APPROVED	<i>DP</i>	TITLE	SCALE
DE APPR.	<i>TP</i>	INSTRUMENT PANEL ASSY'	NTS
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RELEASED
CP7/2025/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

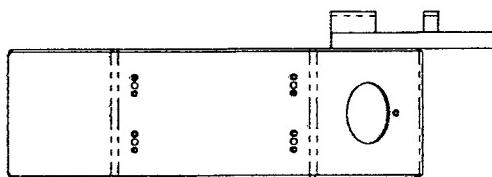
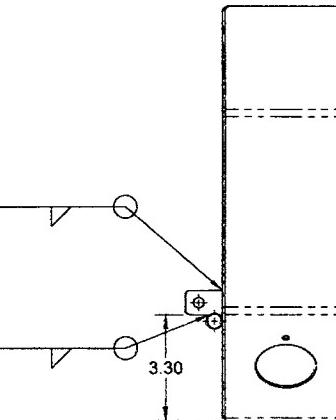
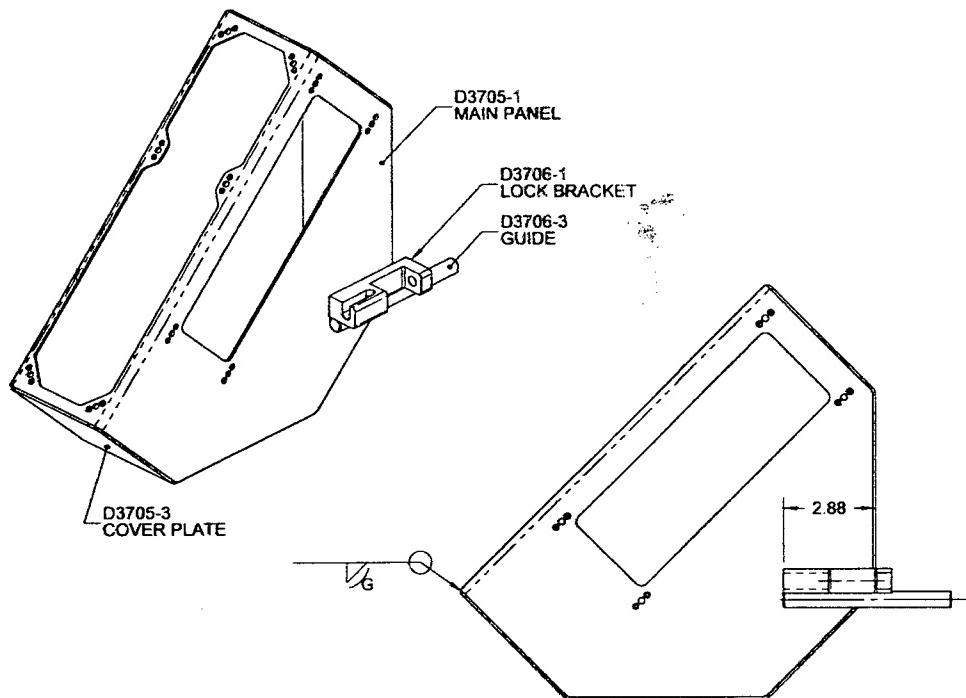
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3705-043 INSTRUMENT PANEL WELDMENT

DESIGN	11	DART AEROSPACE LTD
DRAWN	11	HAWKESBURY, ONTARIO, CANADA
CHECKED	11	DRAWING NO. REV. C
MFG. APPR.	11	D3705 SHEET 2 OF 6
APPROVED	11	TITLE SCALE
DE APPR.	11	INSTRUMENT PANEL ASS'Y NTS
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RELEASED
08/2008 MHD
W/L 55049

- D3705-043 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.90 lbs
 - 8) WELDING: PER DART QSI 004

8

7

6

5

4

3

2

1

A

D

C

B

C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

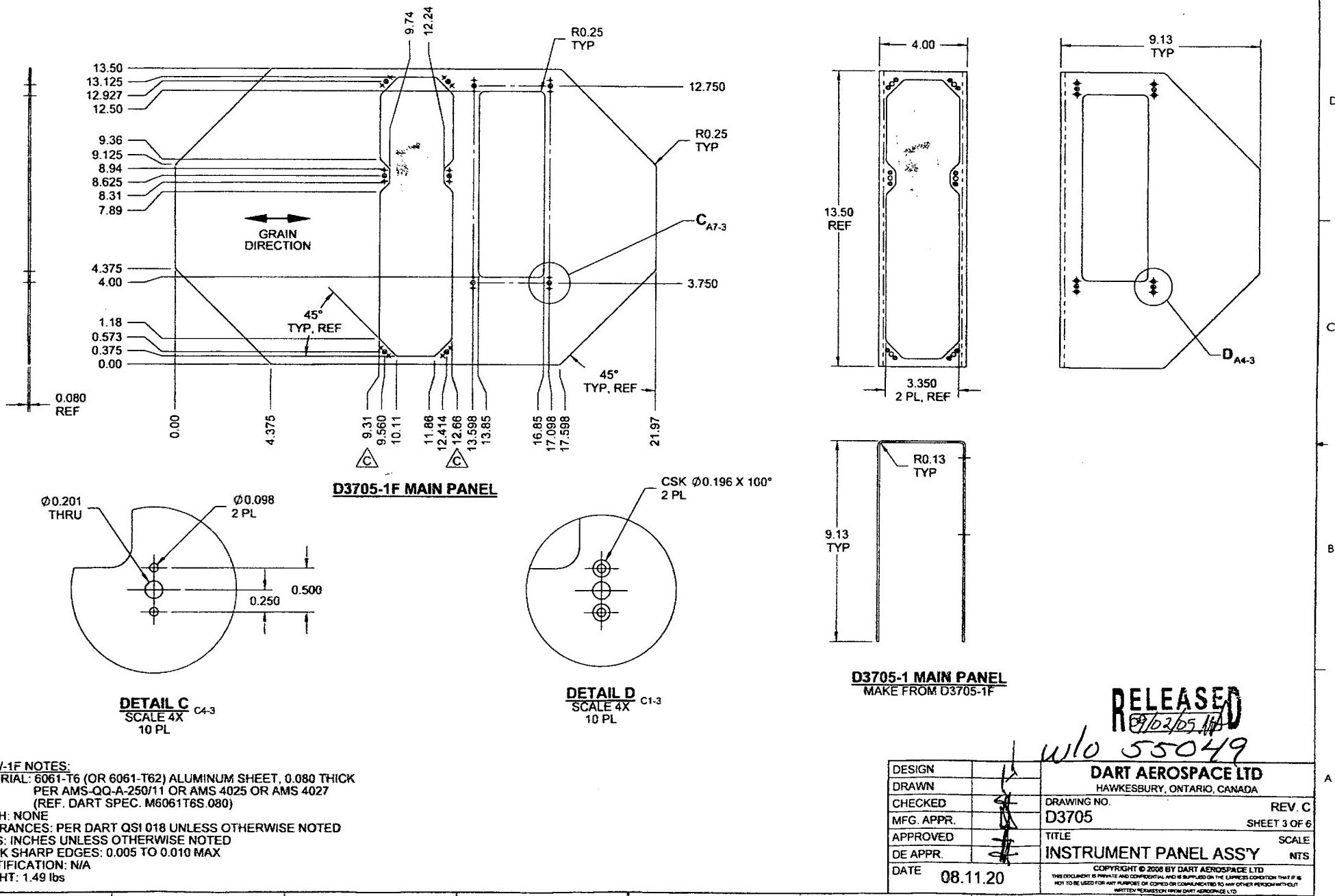
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3705-1-1F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.49 lbs

8 7 6 5 4 3 2 1

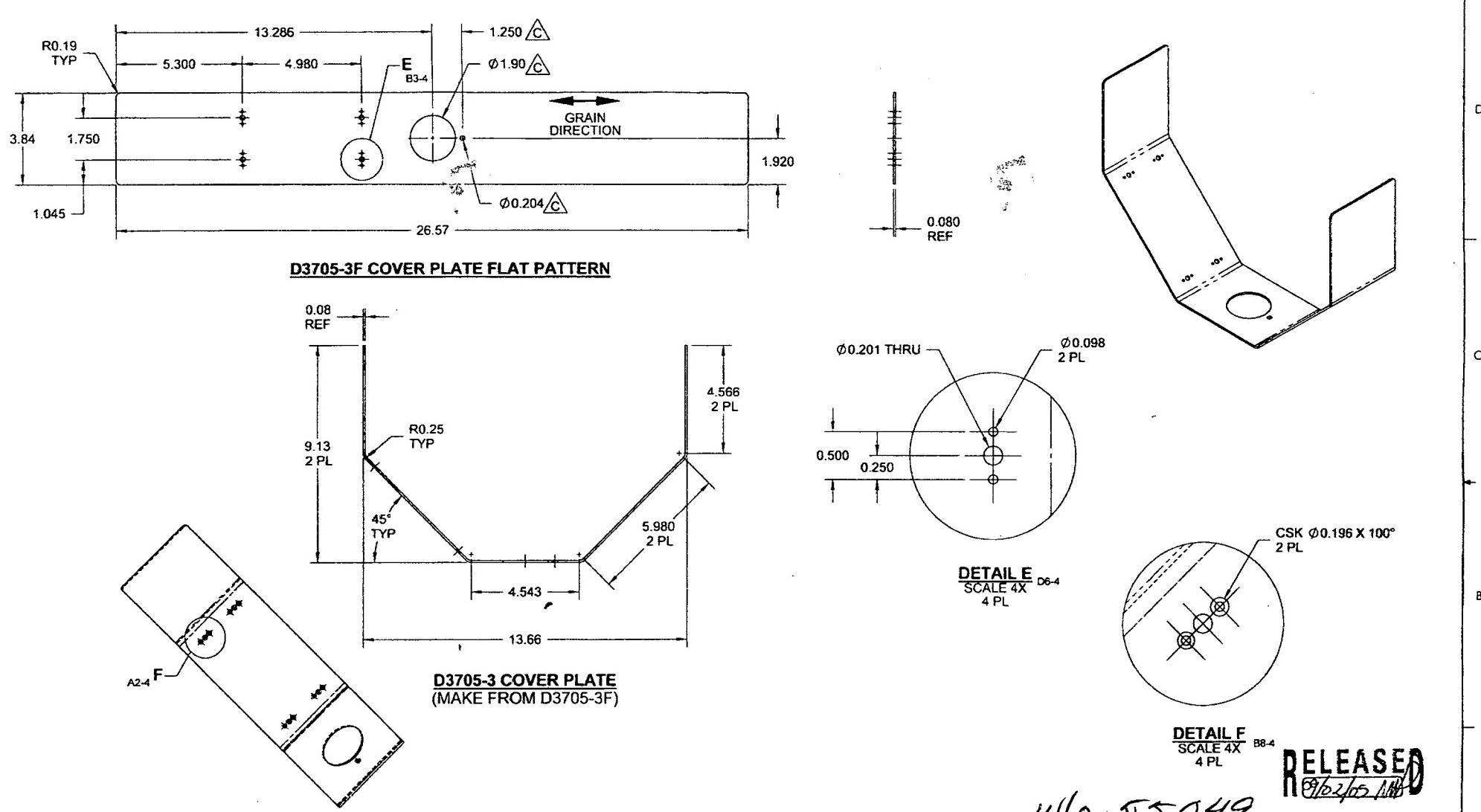
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3705-3/-3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.77 lbs

DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD	
DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO. REV. C	
MFG. APPR.	<input checked="" type="checkbox"/>	D3705	SHEET 4 OF 6
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	INSTRUMENT PANEL ASS'Y NTS	
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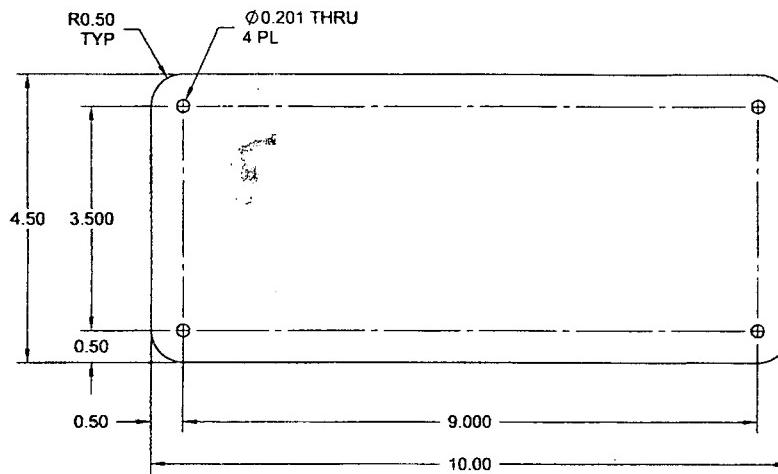
NOTE: Date & initial all entries

D

C

B

A



D3705-5 ACCESS PANEL

RELEASED
9/09/03 AM

w/o 55049

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK PER AMS-QQ-A-250/1 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

DESIGN		HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DRAWING NO.		REV. C
D3705		SHEET 5 OF 6
TITLE		SCALE
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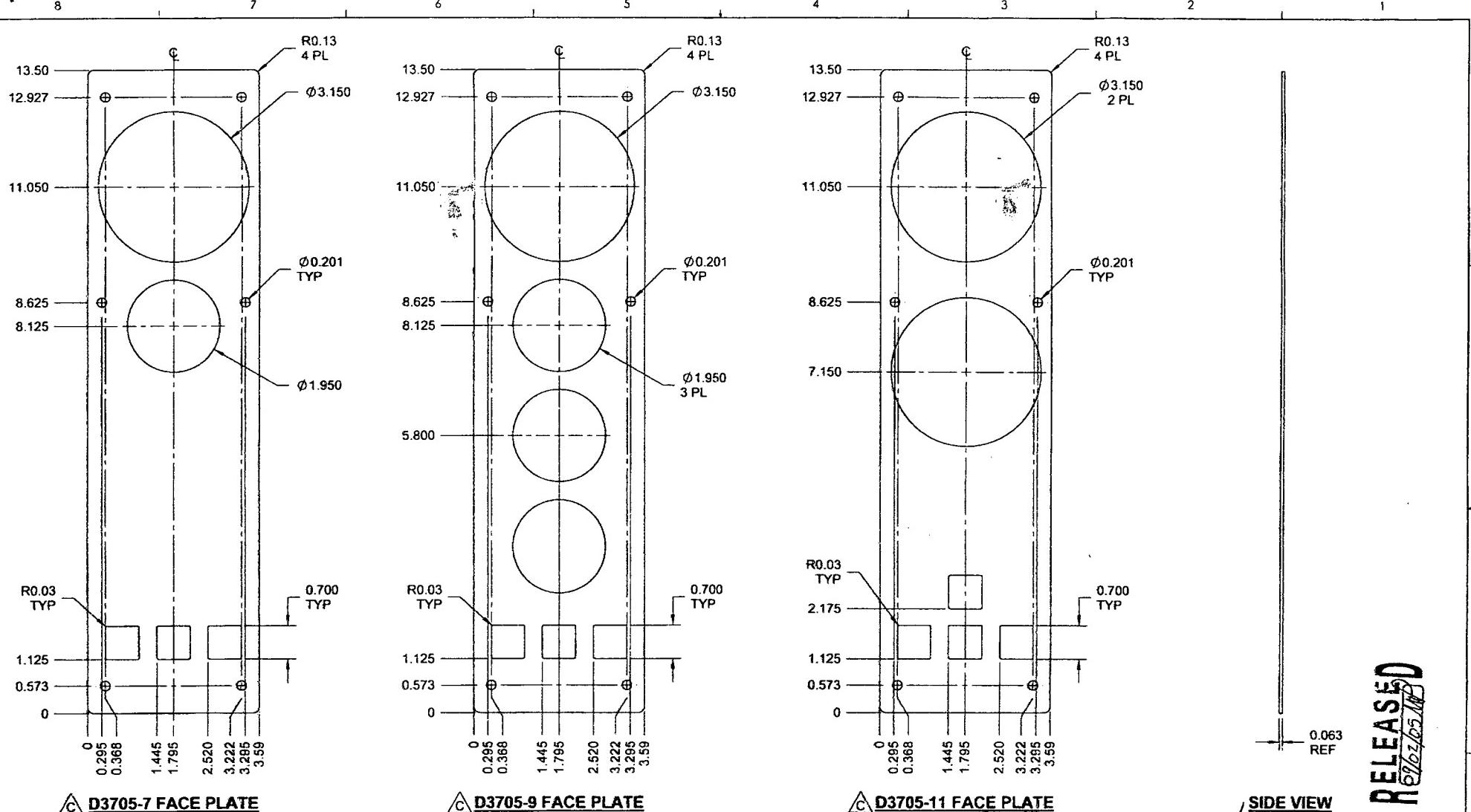
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3705-7/9-11 NOTES:

-) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
-) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
-) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
-) UNITS: INCHES UNLESS OTHERWISE NOTED
-) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
-) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-X" USING WHITE FINE POINT PERMANENT INK MARKER
-) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.16 lbs; D3705-11 = 0.19 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.11.20

W/0 55049

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3705** REV. C
SHEET 6 OF 6

TITLE **INSTRUMENT PANEL ASSY** SCALE **NTS**

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RELEASED
6/16/2015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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